

PHI - Canoflage Blxh ship Nov. 20!

Work Order ID 125635

October-17-14 10:30:22 AM

\*125635\*

Page 1

Item ID: D2842-042

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Step Assembly RH, 206 Float

Stop \*NS2\*

Start Date: 10/17/14 Start Qty: 1.00

\*1\*

Cost Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2842	Rev B								

100

Large Fab

0.00

\*100\*

Large Fab

Memo

0.00

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842  
2-Drill D2842-1 using Jig D70272 as per Dwg D2842 ~~DO NOT OPEN HOLES~~  
3-Deburr and bevel ends for welding

DO NOT DRILL HOLES FOR INSERTS

105

QC6- Inspect dimensions to drawing

0.00

OCT 29 2014

DAS  
24  
9-89

\*105\*

QC

Memo

0.00

Quality Control

AL 14/10/27



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Item ID: D2842-042

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Step Assembly RH, 206 Float

Start Date: 10/17/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSR005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
160	Weld per dwg. A/R Aluminum rod Batch: <u>128756</u>	0.00							
<b>*160*</b>									
Large Fab	Memo	0.00							
Large Fab	1-Remove alindine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.								

1xRH of del acc 105

DAS  
38  
9-89

NOV 05 2014

NOV 07 2014

DAS  
24  
9-89



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Item ID: D2842-042

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Step Assembly RH, 206 Float

Stop **\*NS2\***

Start Date: 10/17/14 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
195		0.00							DAS 41 9-89
<b>*105*</b>						1			
SprayPaint	Memo	0.00							
Spray Painting	1- PRIME AS PER DWG AND OSI 005 4.2 USE: PRC Dasoto Primer 515X349 (Boeing Spec BMS 10-79 Type III Class A Grade A) <b>128975</b>								14-11-16
	2-SPRAY PAINT PER OSI USE: CA 8213/F37038 CAMOFLAGE BLACK - MIL-PRF-05285B, TYPE I, CLASS H <b>130804</b>								
205	QC14- Inspect Spray Paint	0.00							
<b>*205*</b>									
QC	Memo	0.00							
Quality Control									

1x f ll 4/6/12

DAS  
15  
9-89

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Item ID: D2842-042

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Step Assembly RH, 206 Float

Start Date: 10/17/14 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	HandFinishing	0.00							
*210*	HandFinish	0.00							
Hand Finishing	Memo	0.00							
	<del>1-Install inserts as per Dwg D2842</del> DO NOT INSTALL INSERTS #								
	2-Wing Walk as per Dwg D2842 and QSI 005 4.1								
	Batch: 1130289								
220	OCS- Inspect part completeness to step on W/O	0.00							
*220*	QC	0.00							
Quality Control	Memo	0.00							
230	Identify as per dwg & Stock Location: _____	0.00							
*230*	Packaging	0.00							
Packaging	Memo	0.00							

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DAS  
38  
9-89

NOV 19 2014

PP125613

DAS  
46  
9-89

NOV 24 2014

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Item ID: D2842-042

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Step Assembly RH, 206 Float

Stop **\*NS2\***

Start Date: 10/17/14 Start Qty: 1.00

**\*1\***

Cost Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC21- Final Inspection - Work Order Release

0.00

**\*240\***

QC

Momen

0.00

Quality Control

MLJ 14-11-24

14-11-24

# Picklist Print

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Work Order ID: 125635

**\*125635\***

Parent Item: D2842-042

**\*D2842-042\***

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 10/17/14

Required Date: 11/07/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured No

110 Each 47.0000 1 1

**\*D2622-120C\***

Step Extrusion

\*\*

DL 14/10/21

Location	Loc Qty	Loc Code
----------	---------	----------

HALL 43

109575 32

119621 11

WA003 4

101765 1

115141 3

D2734

Manufactured No

110 Each 33.0000 2 2

**\*D2734\***

Step End Plate

\*\*

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DAS  
24  
9-89

Location	Loc Qty	Loc Code
----------	---------	----------

WA003 33

119286 21

119498 11

99709 1

D3459-1

Manufactured No

110 Each 3.0000 2 2

**\*D3459-1\***

Float Step Mounting Plate

\*\*

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DAS  
24  
9-89

Location	Loc Qty	Loc Code
----------	---------	----------

WA003 3

113244 2

121120 1

B 124893 →



# Picklist Print

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Work Order ID: 125635

**\*125635\***

Parent Item: D2842-042

**\*D2842-042\***

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 10/17/14

Required Date: 11/07/14

Start Qty: 1.00

Required Qty: 1.00

D3459-3

Manufactured No

210

Each

30.0000

2

2

**\*D3459-3\***

Float Step Mounting Plate

\*\*\*

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DAS  
24  
9-89

Location

Loc Qty

Loc Code

B 124190 → 2

WA003

30

116810

10

124190

20

MS27039C1-07

Purchased

No

210

Each

91.0000

3

3

**\*MS27039C1-07\***

SCREW

Location

Loc Qty

Loc Code

ST288

91

124580

3

m127305

15

m128401

23

m130566

50

NAS1149C0332R

Purchased

No

100

Each

8,749.000

3

3

**\*NAS1149C0332R\***

WASHER

Location

Loc Qty

Loc Code

CA

83

m129682

83

ST278

8666

122063

41

125654

425

m126319

31

m127306

2065

m127831

26

m128591

75

m129499

191

m130325

4792

m130466

1000

N/A

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Shop Packet Print

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# Picklist Print

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**\*125635\***

Parent Item: D2842-042

**\*D2842-042\***

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 10/17/14

Required Date: 11/07/14

Start Qty: 1.00

Required Qty: 1.00

NAS1329C3KB130		Purchased	No	210	Each	82.0000	3	3
*NAS1329C3KB130*							**	
Insert								
		<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>		
		FP001			61			
		m127836			11			
		m130281			50			
		ST			21			
		m129207			21			
NAS1515H3L		Purchased	No	210	Each	265.0000	3	3
*NAS1515H3I *							**	
Washer								
		<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>		
		PG			40			
		102472			40			
		ST273			225			
		m127831			136			
		m128976			89			

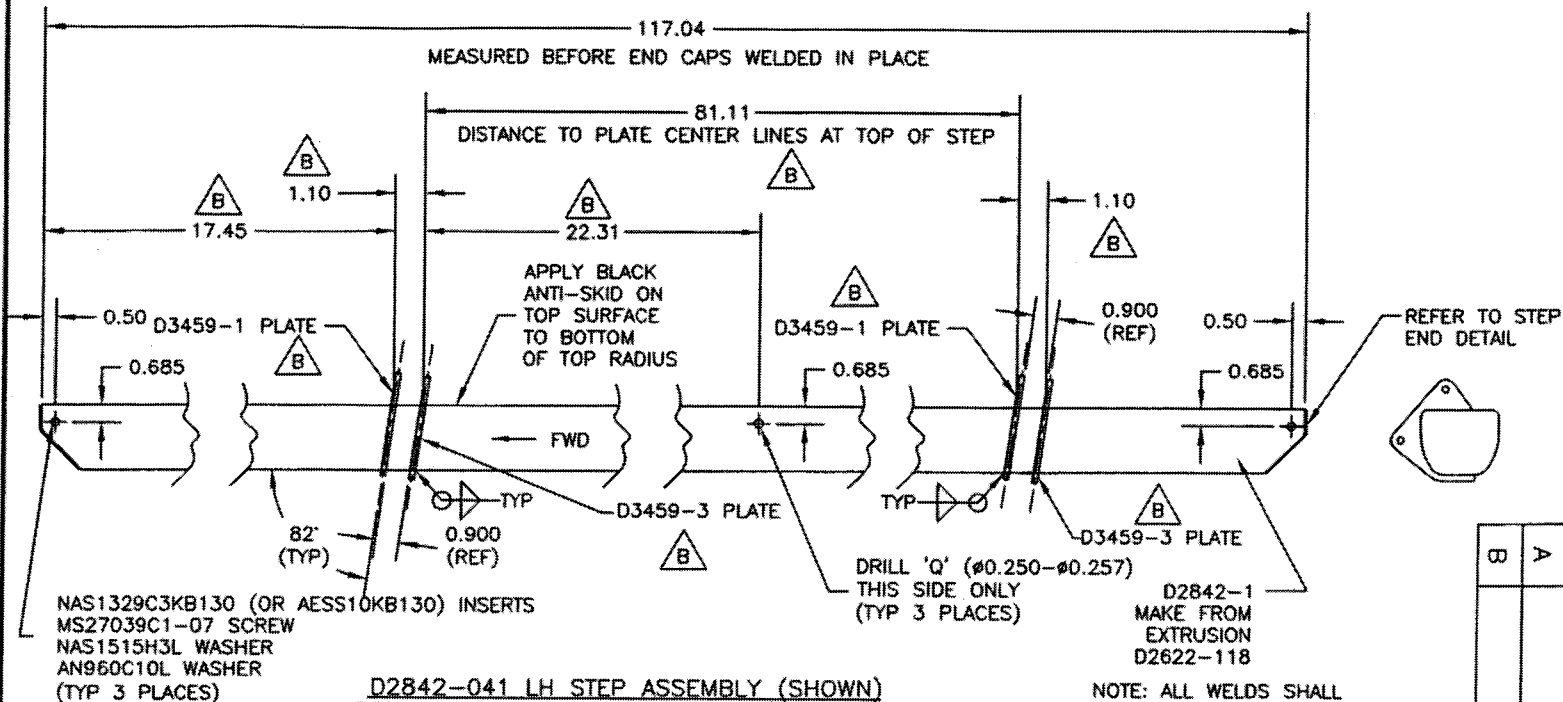
N/A  
NOT REQUIRED - 11

October-17-14 10:30:21 AM

Shop Packet Print

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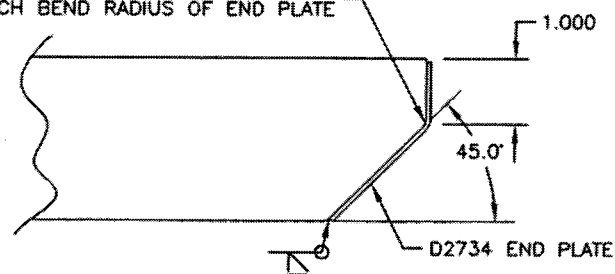
# DART



**D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN950C10L	WASHER

ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE





TYPICAL STEP END DETAIL  
NOT TO SCALE

**D2842-041/-042 FLOAT STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004

DESIGN	UNKNOWN BY	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
KE	PH		
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2842	SHEET 1 OF 1
DATE		TITLE	SCALE
05.09.23		206L/407 FLOAT STEP ASSEMBLY	NTS
A	98.10.13	NEW ISSUE	
B	05.09.23	RE-DESIGN, ADD D3459-1/-3	

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RELEASED  
05-11-14